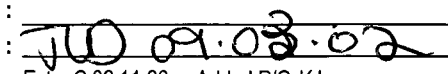


Date: Monday, 02/03/2009 10:10:08 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	02.250 SUPPORT
Job Number :	46159		
Estimate Number :	11057		
P.O. Number :		Part Number :	D28911
This Issue :	02/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2891 REV A1
First Issue :	//	Project Number :	N/A
Previous Run :	45934	Drawing Revision :	A1
		Material :	
Written By :		Due Date :	02/04/2009
Checked & Approved By :			Qty: 20 Um: Each
Comment :	Est. C 02.11.26 Added P/O KJ Est. D 08.03.19 Re-format EC verified: DD		

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

DSK076

D2891-1 TURNING DETAIL



Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s)

D2891-1 TURNING DETAIL- B 433841

Batch: B44410X8

JL 09/03/18

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

Machine as per Folio FA046

Tumble & Deburr

JL / mdf = 09/03/19

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL / mdf = 09/03/19

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 09/03/23

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

8:45

OVEN TEMPERATURE:

400°

FINISH TIME:

9:15

umd / Fed

09/03/24

(x20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 10:10:08 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 SUPPORT

Job Number: 46159

Part Number: D28911

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



26

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-03-24

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Gross tube Assy (I AW)

28 09/03/24 (x20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46159
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.251	.251	.252	.249	.250
AC	0.115	0.150		.127	.127	.127	.126	.125
AD	0.040	0.060		.052	.051	.050	.050	.050
AE	0.010	0.020		.015	.015	.015	.015	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.295	.295	.295	.295	.295
AH	0.115	0.150		.138	.139	.138	.138	.138
AI	0.454	0.474		.463	.463	.464	.464	.454
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.037	1.024	1.034	1.032	1.035
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.258	.258	.258	.258	.258
AO	1.663	1.683		1.676	1.676	1.676	1.676	1.668
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: JL	Date: 09/03/18
Audited by: LS	Date: 09/03/18
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 46159
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.251	.251	.252	.250	.251
AC	0.115	0.150		.126	.125	.127	.127	.126
AD	0.040	0.060		.051	.051	.051	.053	.052
AE	0.010	0.020		.015	.015	.015	.012	.012
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.295	.295	.295	.297	.300
AH	0.115	0.150		.138	.138	.138	.140	.140
AI	0.454	0.474		.454	.464	.464	.464	.463
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.034	1.031	1.035	1.042	1.040
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.258	.258	.258	.258	.258
AO	1.663	1.683		1.668	1.677	1.677	1.678	1.677
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L. / mms Date: 07/03/19

Audited by: SP Date: 09/03/23

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 46159
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	0.188	0.193		.190	.190	.190	.190	.190
AB	0.240	0.260		.247	.246	.252	.255	.249
AC	0.115	0.150		.127	.125	.125	.132	.129
AD	0.040	0.060		.053	.050	.053	.054	.055
AE	0.010	0.020		.015	.015	.015	.013	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.291	.295	.291	.300	.291
AH	0.115	0.150		.140	.138	.138	.145	.135
AI	0.454	0.474		.455	.455	.454	.454	.465
AJ	2.779	2.789		2.783	2.783	2.783	2.783	2.783
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.038	1.042	1.034	1.040	1.038
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.259	.259	.259	.259	.260
AO	1.663	1.683		1.671	1.672	1.669	1.666	1.676
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: mme	Date: 09/03/19
Audited by: [Signature]	Date: 09/03/23
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	[Signature]

DART AEROSPACE LTD		Work Order: 410159
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

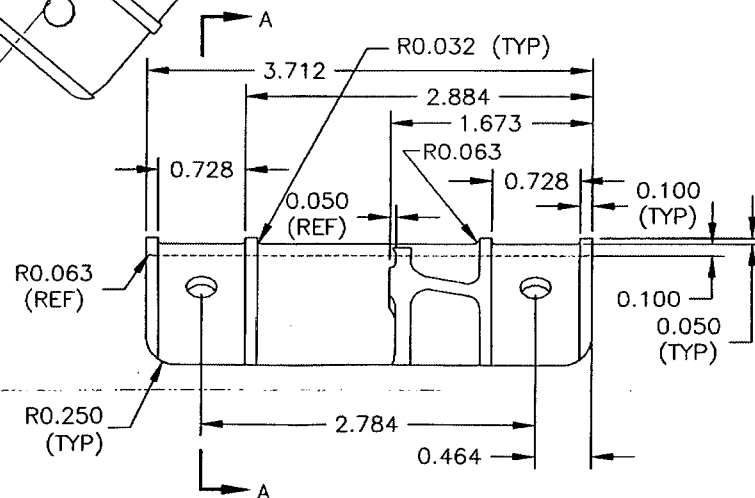
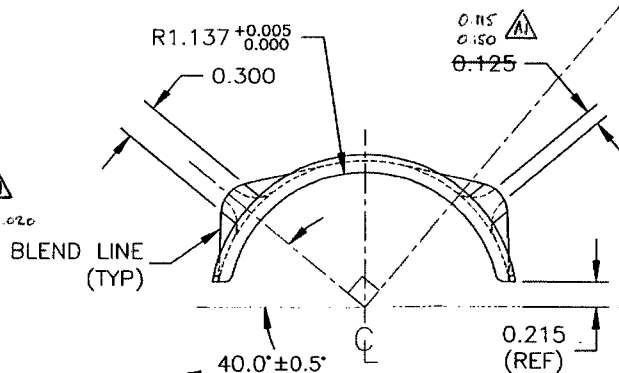
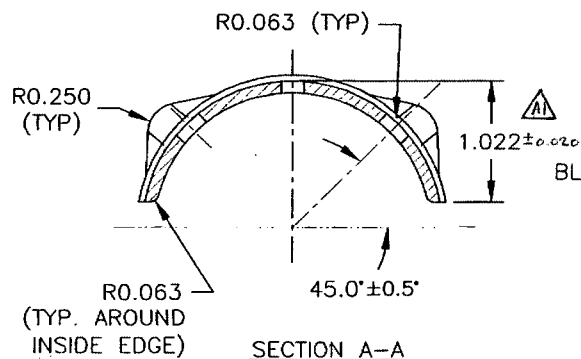
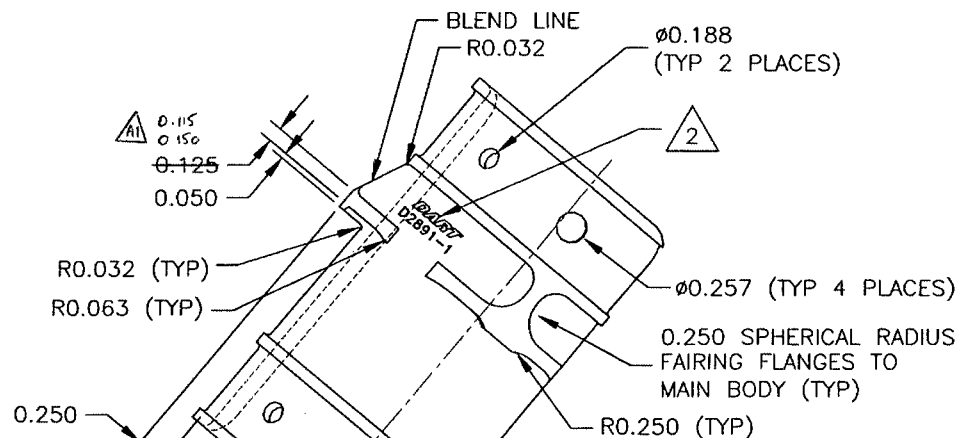
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		.190	.190	.190	.190	.190
AB	0.240	0.260		.249	.249	.250	.247	.249
AC	0.115	0.150		.127	.125	.124	.125	.123
AD	0.040	0.060		.053	.053	.053	.050	.050
AE	0.010	0.020		.015	.015	.015	.015	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.291	.300	.300	.306	.301
AH	0.115	0.150		.135	.138	.136	.137	.138
AI	0.454	0.474		.463	.462	.463	.466	.465
AJ	2.779	2.789		2.783	2.782	2.783	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.037	1.043	1.037	1.038	1.038
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.259	.259	.259	.259	.259
AO	1.663	1.683		1.676	1.675	1.676	1.677	1.675
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: mmf	Date: 09/03/19
Audited by: JB	Date: 07/03/23
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



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AI	02.01.23	UPDATE DIMS AS MANUFACTURED
A	00.11.17	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	CP	APPROVED
DATE	00.11.17	TITLE
		D2891
		02.250 SUPPORT
		REV. A
		SHEET 1 OF 1
		SCALE
		1:1



DART DART AEROSPACE LTD.
MARKHAM, ONTARIO, CANADA